

Date: Wednesday, 5/31/2006 7:40:20 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHORT STEP INSTALLATION KIT
Job Number :	27308		
Estimate Number :	10542		
P.O. Number :	N/A	Part Number :	K591113
This Issue :	5/31/2006	Drawing Number :	D350-591 REV F PG17
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	F
Previous Run :	27046	Material :	N/A
Written By :	SKY COMMENT	Due Date :	6/30/2006
Checked & Approved By :	06.05.31	Qty:	6
Comment :	Est: 04.11.09 Reformat KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2171	Clamp
-----	-------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Clamp

Pick:

Qty	Part Number	Description	Batch
2	D2171	Clamp	B23371 x 3

6.33

B2244 x 11

2.0	D2182B	Neoprene Cushion-.750 bl
-----	--------	--------------------------



Comment: Qty.: 0.5833 f(s)/Unit Total : 3.4998 f(s)

Neoprene Cushion-.750 bl

Pick:

Qty	Part Number	Description	Batch
7"(2 x 3.5")	D2182B	Cushion	B24810

3.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Radius Block

Pick:

Qty	Part Number	Description	Batch
4	D2274	Radius Block	B26078

4.0	D23623	Step Support Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Support Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2362-3	Support Bracket	B27309

SB 06/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:40:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 27308

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 3.6000 f(s)

Abrasion Strip

Pick:

Qty	Part Number	Description
7.2"	D2856-400	Abrasion Strip

Batch
B26041 ✓

6.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN3-37A	Bolt

Batch
M14478 ✓

7.0

AN420A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
4	AN4-20A	Bolt

Batch
M14855 ✓

8.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
1	AN4-22A	Bolt

Batch
M14620 ✓

9.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	AN960JD10	Washer

Batch
M100743 ✓ ~~06/06/07~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:40:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 27308

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	AN960JD416	Washer

Batch

M100575 ✓

11.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	MS21042L3	Nut

Batch

M100393 ✓

12.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
5	MS21042L4	Nut

Batch

M19085 ✓

06/06/07

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

06/07/10

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/11

Job Completion



06.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
8	4	4	4	4		AN4-20A	BOLT
1	1	1		1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	6	4	6	14	AN960JD416	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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